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D3914-041
Job Sheet 188730



Part No: D3914-041

Job Qty: 1 ea

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/15/19

Job Tracking No:

Due Date: 2/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/8/19	0.00	0.00	Start Up Large Fab-5		
100	Large Fab	1 pcs		2/8/19	0.00	6.67	Large Fab 1		
110	QC	1 pcs		2/8/19	0.00	0.00	QC9		
120	QC	1 pcs		2/8/19	0.00	0.00	QC5		
130	Powdercoat	1 pcs		2/8/19	0.00	0.40	Powdercoat4		
135	QC	1 pcs		2/8/19	0.00	0.00	QC3		
140	HandFinish	1 pcs		2/8/19	0.00	0.80	HandFinish3		
150	QC	1 pcs		2/8/19	0.00	0.00	QC3		
160	Packaging	1 pcs		2/8/19	0.00	0.00	Packaging3-2		
170	QC21-SA	1 Ea		2/8/19	0.00	0.00	QC21		

Part Op 100 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg
Descriptions: D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where
label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label
plate before tacking mesh***

130 - *** mask sides of hinge prior to powdercoat***

140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask
label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

MB8940 START: 11:20 TEMP: 320° FINISH: 11:50

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581 ✓	Mounting Bracket	2 pcs (2 ea) ✓	90-Start up Operation	5143339
D3914-1 ✓	Rib	2 pcs (2 ea) ✓	90-Start up Operation	5149804
D3914-7 ✓	Rib	2 pcs (2 ea) ✓	90-Start up Operation	5144903
D4016-3 ✓	Hinge Half, Lid	3 pcs (3 ea) ✓	90-Start up Operation	5110937
D4018-5 ✓	Rib	9 pcs (9 ea) ✓	90-Start up Operation	5146891
D4020-5	Mesh (350 Basket Long, Lid)	1 pcs (1 ea)	90-Start up Operation	5153498
D4021-3 ✓	Data Plate	1 pcs (1 ea) ✓	90-Start up Operation	5114284
D4035-043 ✓	Lid Rib Assembly, Aft (350 Basket)	2 pcs (2 ea) ✓	90-Start up Operation	5148540

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
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90-Start up Operation

D2581	2	63	0
D3914-1	2	4	0
D3914-7	2	4	0
D4016-3	3	174	0
D4018-5	9	48	0
D4020-5	1	5	0
D4021-3	1	10	0
D4035-043	2	8	0

Part Specifications

Specifications could not be found.

Plex 1/15/19 8:04 AM Dart.lajeunesse.marie



Container No: S153784



Part: D3914-041

Job No: 188730

Serial No/Batch: S153784

Revision: A/D

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 02/14/19